

Work Order ID 71094

Wednesday, June 22, 2011 11:29:52 AM



Page 1

Soon

Item ID: D3986-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Brace

Start Date: 6/23/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-22

Tooling:

Date:

Run Start





QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3986	A								
100	FLOW WATER JET	0.00							
 Waterjet	Memo 1-Cut as per Dwg D3986 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary	0.00							
FLOW CNC Waterjet 6061-063									(40)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									

B11-6-22

B11-6-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sublet/23

counts
x40

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3986

0.00

0.00

SB 11/6/24

40

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sublet/24

counts
x40

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

40, 11-6-27

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40 11/26/27

180

Identify as per dwg & Stock Location: 103

0.00



Packaging

Memo

0.00

Packaging

40 11/26/28 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 J

11-06-28

(40)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 22, 2011 11:29:47 AM

Page 1

Work Order ID: 71094



Parent Item: D3986-3



Parent Item Name: Brace



Start Date: 6/23/2011

Required Date: 6/30/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP revA 11.06.22 new issue EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	243.1700	0.085	2.147368	3.5		
											181-6-22		

Location

Loc Qty

Loc Code

MAT021

243.17

116308

28.5

117285

214.67

117285

(40)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

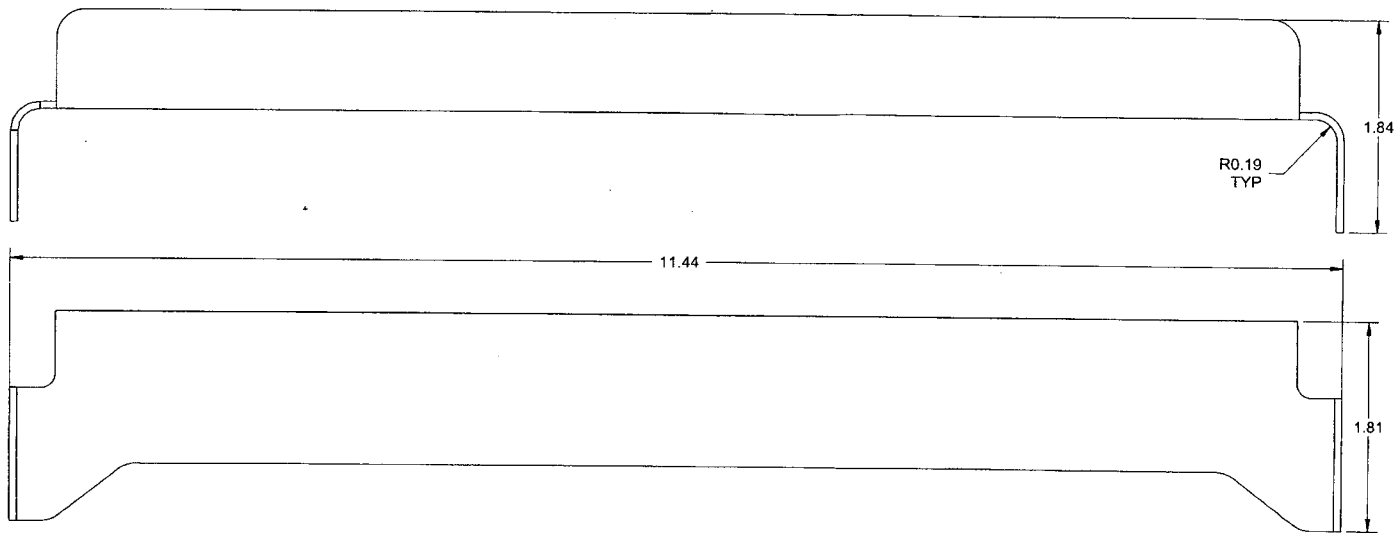
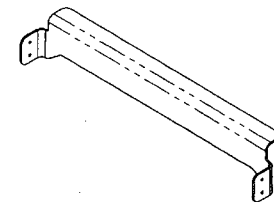
C

B

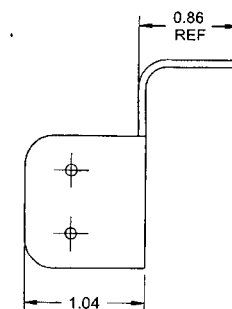
B

A

A



#71094



D3986-1 ANGLE

RELEASED
2011-06-16

- NOTES:
- 1) MATERIAL: MADE FROM D3986-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 0.15 lbs

A	NEW ISSUE		11.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3986 REV. A
SHEET 1 OF 4
TITLE ANGLE/BRACE
SCALE NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

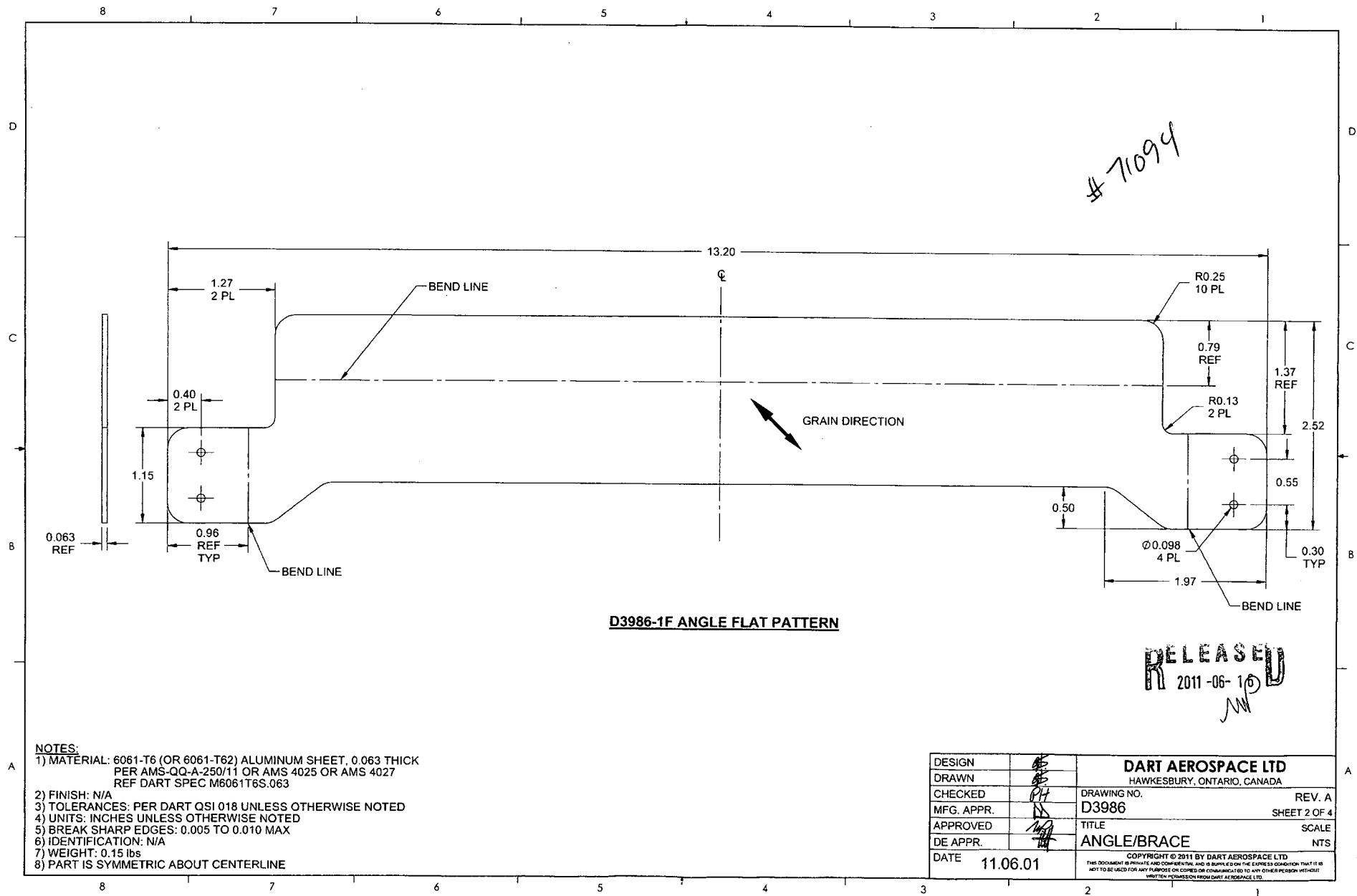
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#71094



D3986-1F ANGLE FLAT PATTERN

RELEASED
2011-06-10

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.15 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3986	SHEET 2 OF 4
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DE APPR.		ANGLE/BRACE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

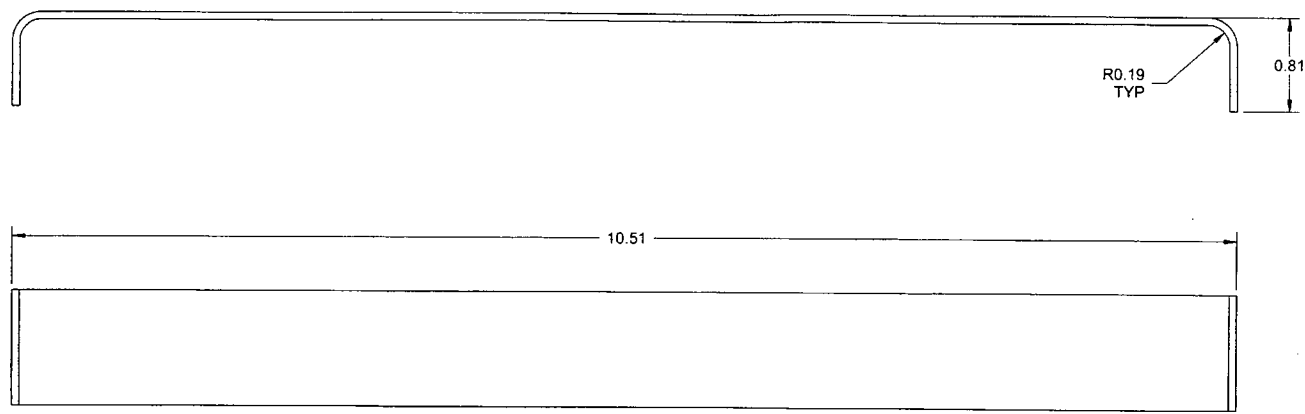
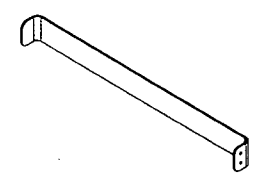
C

B

B

A

A



#71094

D3986-3 BRACE

RELEASED
2011-06-16
JW

NOTES:

- 1) MATERIAL: MADE FROM D3986-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JS	SHEET 3 OF 4	
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DATE	11.06.01		

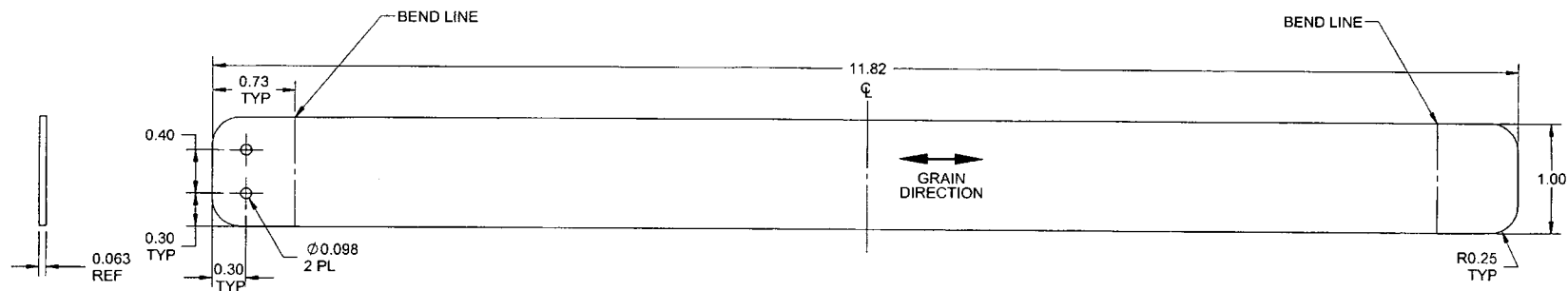
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NOTE: Date & initial all entries



D3986-3F BRACE FLAT PATTERN

RELEASED
2011-06-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

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		D3986	SHEET 4 OF 4
		TITLE	SCALE
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